Monday, 9/25/2006 11:07:27 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28713

Estimate Number

: 10822

P.O. Number

: N/A

This Issue

: 9/25/2006 : NC

: NA : 28344

S.O. No. : NA

Type

: MACHINED PARTS

Part Number

Material

Due Date

Drawing Name

: D2274

: D2274 REV F

: RADIUS BLOCK

Drawing Number Project Number

: N/A

Drawing Revision

: 10/2/2006

Qty:

500 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est. H 00.05.14

Added inspection level 8 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6B0750X00125

6061-T6 Bar .75" x .125"

Comment: Qty.:

0.0962 f(s)/Unit

Total: 48.0900 f(s)

6061-T6 Bar .75" x .125"

SHEAR

2.0



Comment: SHEAR

Shear blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

3.0 HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

4.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

500

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6110126

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							·		
			<u> </u>				<u> </u>		
Part No	:	PAR #: Pault Category: NC	R: Yes	No DQ	A: 🔊	Date:	06/11/10		

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	A I				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
···											
					·						
							7				

NOTE: Date & initial all entries

Date: User:	Monday, 9/25/2006 11:07:27 AM Kim Johnston	Process Sheet	
Custo	mer: CU-DAR001 Dart Helicopters Se		ADIUS BLOCK
lah Num	nber: 28713	Ded North on D	2274
Job Number		Part Number: D2	
Seq. #:	Machine Or Operation:	Descri	iption :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOUR	
Co	omment: SMALL & MEDIUM FAB R Tumble	ESOURCE 1	mloc/11/06 500
	Deburr any rough edges at	ter tumbling	~ 06/10/25 500
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			1 counted α
Co	omment: HAND FINISHING RESOU Chemical Conversion Coat	00 707 001 005 4.1	ac/1/09 X
8.0	QC3	INSPECT POWDER COAT/CHEM	ICAL CONVERSION
		Λ	
	mment: INSPECT POWDER COAT		3 06/11/10 (504)
9.0	PACKAGING 1	PACKAGING RESOURCE*#1	
Co	mment: PACKAGING RESOURCE	#1	
40.0	Identify and Stock Location: 57.35	FINAL INSPECTION/W/O RELEAS	B 06/11/10 (504)
10.0	QC21	FINAL INSPECTION/W/O RELEAS	504)
Co	omment: FINAL INSPECTION/W/O	RELEASE	9 06/11/10
Job Completion			Wall-10
	1 (00)310 01010 1101 1803 1803 1903 1901		4 doll. (0

Dart Ae	rospace	Ltd							
W/O:				ORK ORDER CHANGES					
DATE	STEP		OCEDURE CH	ANGE	Ву		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								•• • • • •	
		·							
Part No	•	PAR #:	Fault Cat	egory: NC					
NCR:			WORK ORI	DER NON-CONFORMANCI				_ Date:	
		Description of NC	Corrective Action Section B				tion	Annacial	A
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28713
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

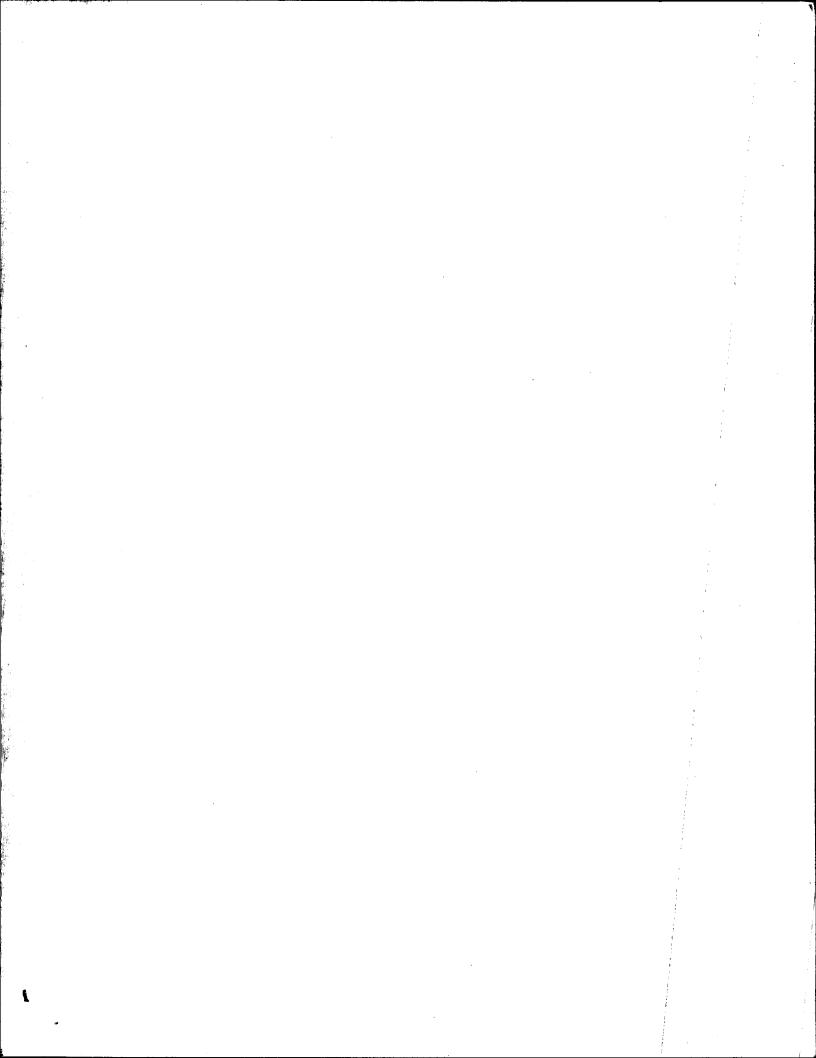
FIRST ARTICLE INSPECTION CHECKLIST

		X First A	Prot	Prototype		
Drawing	Toloropoo	Actual	Assent	Paicet	Method o	
Dimension	Tolerance	Dimanaian	Accept	Reject	Inspection	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	\$0.258	/			
0.750	+/-0.010	0,747				
0.375	+/-0.010	0.374				
0.125	+/-0.010	0,126	/			
0.750	+/-0.010	0.754				
0.063	+/-0.010	0.056	_			

Measured by:	gn/	Audited by:	J.L	Prototype Approval:	· VIA
Date:	06/10/19	Date:	06/10/16	Date:	Poo

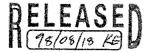
Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	

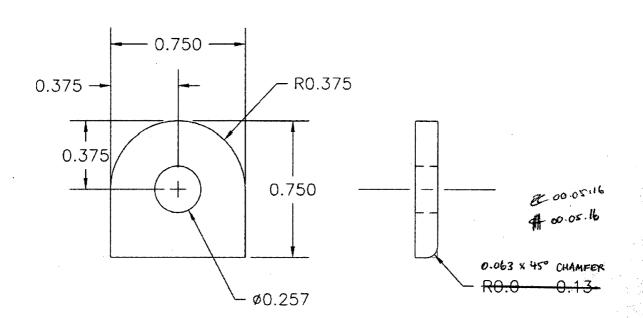






DESIG	KE KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	- III
CHEC	KED /	APPROVED	DRAWING NO. RE	V. F
	N. M.	4	D2274 SHEET 1 C	OF 1
DATE		7	TITLE SC	ALE
98.0	08.11		RADIUS BLOCK	2:1
Α		94.09.29	NEW ISSUE	
С		95.07.12	RADIUS ENDS	
D		97.03.24	ADD MATERIAL SPECIFICATION	
E		97.12.12	ADD FINISH & TOLERANCE QSI	
F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	





SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK WILL OR 6061-T6 (QQ-A-250/11) 0.125 THICK NO. 2

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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